

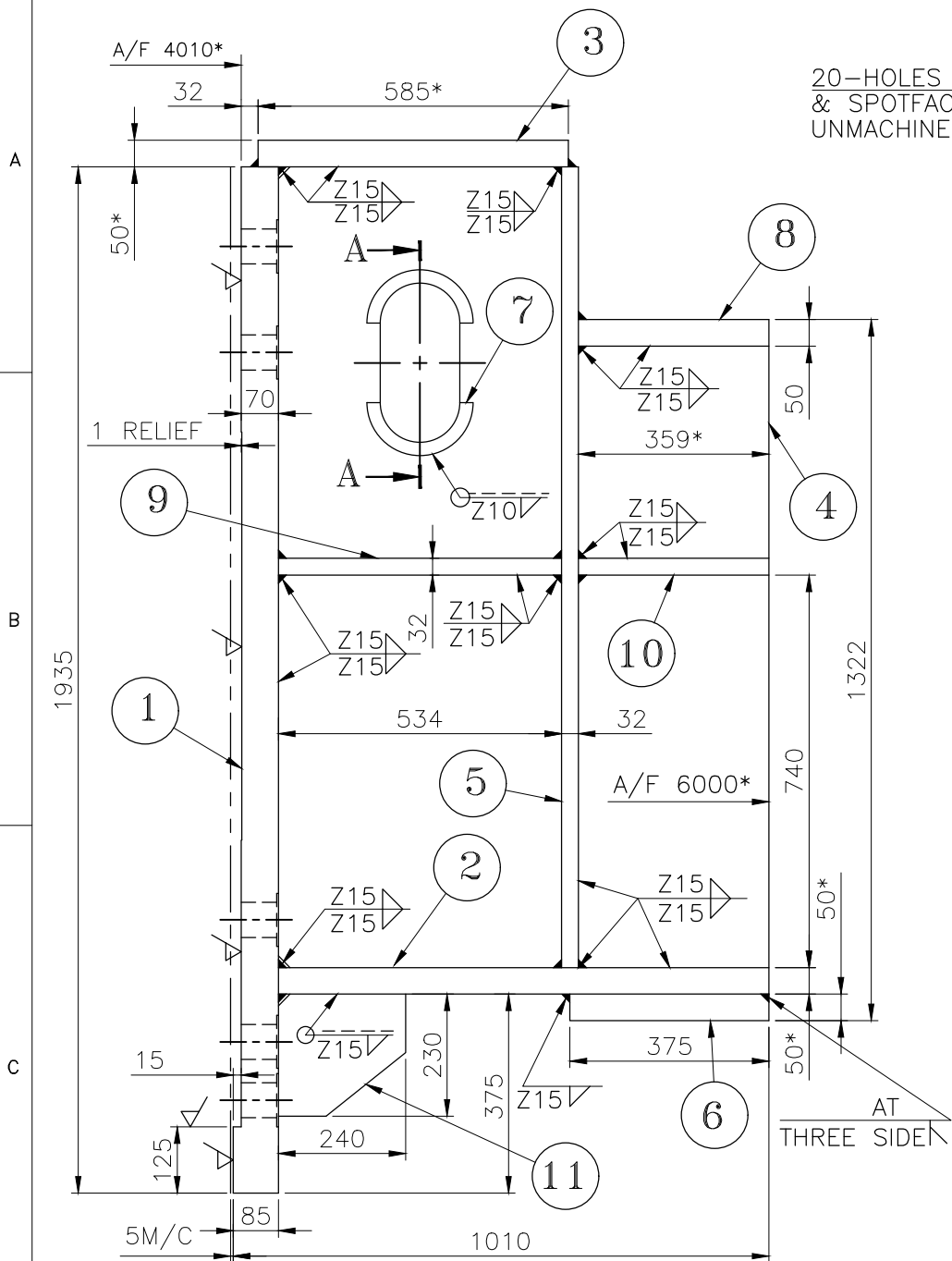
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REF. DRG. NO.
SIGN AND DATE
INVENTORY NO.

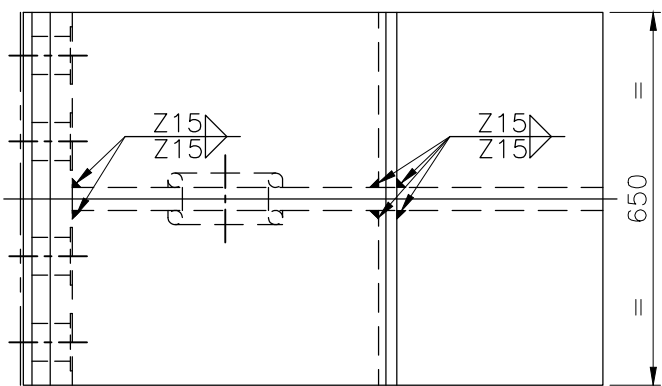
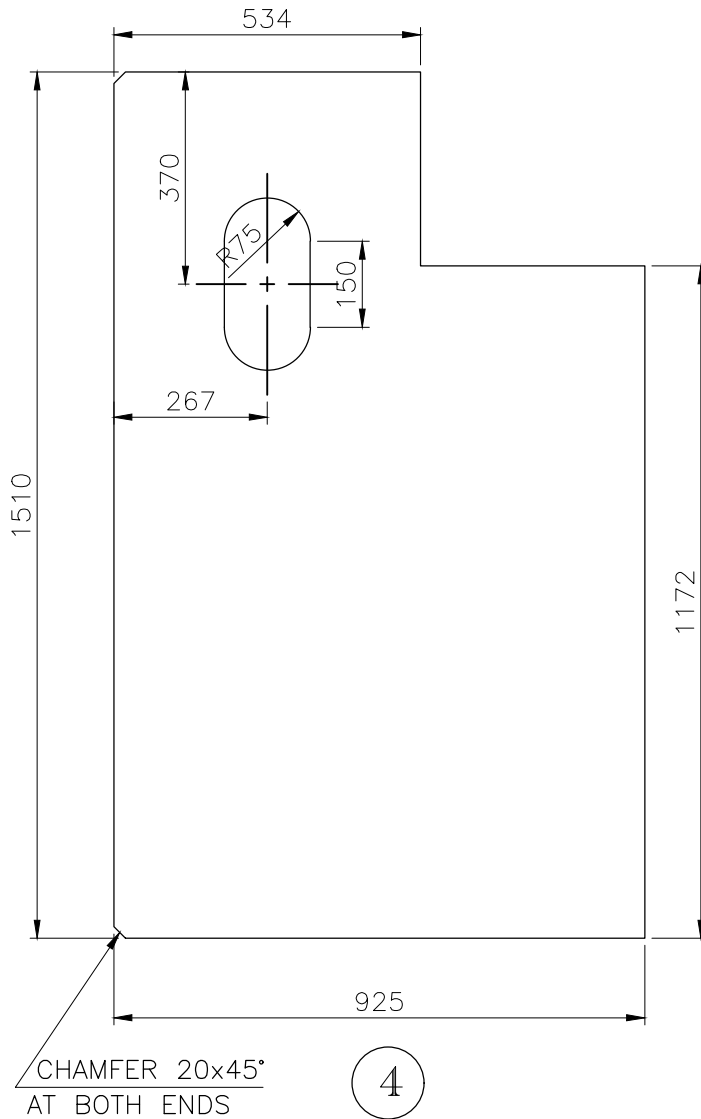
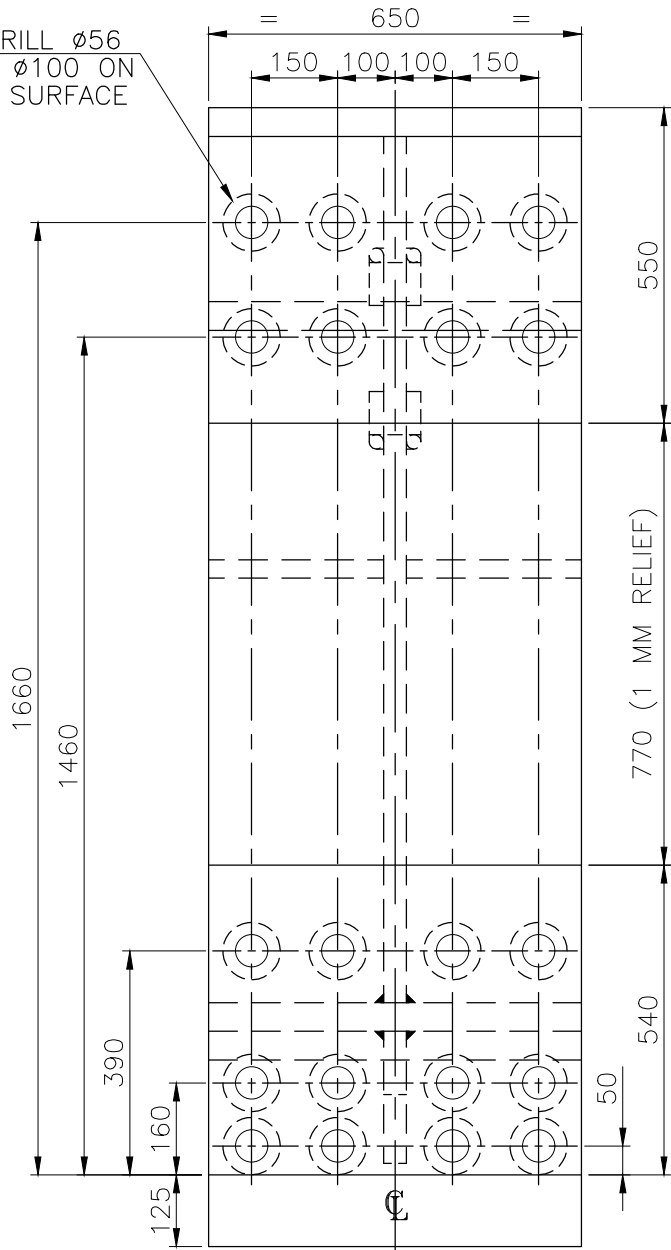
FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm

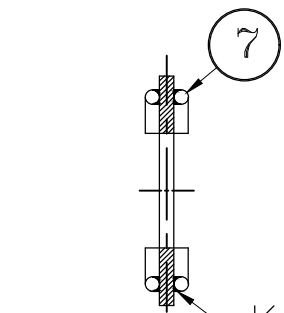
DRG. NO. 2 257 01 89603



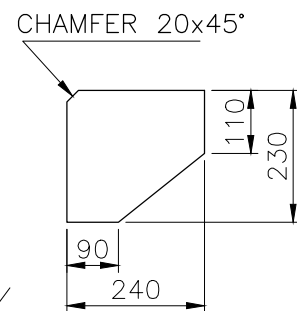
20-HOLES DRILL $\phi 56$
& SPOTFACE $\phi 100$ ON
UNMACHINED SURFACE



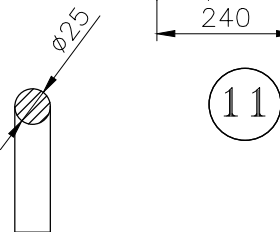
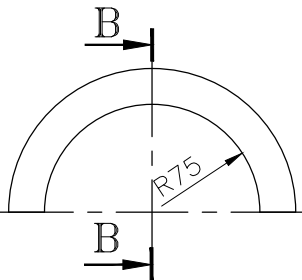
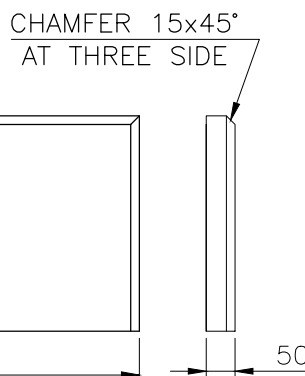
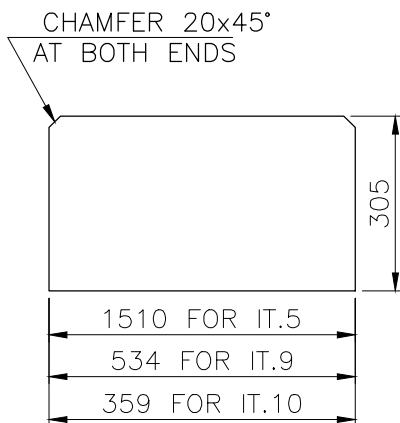
ASSEMBLY



SECTION-AA



SECTION-BB



TECHNICAL REQUIREMENTS:-

- 1 ALL WELDS ARE CONTINUOUS 15 MM FILLET UNLESS OTHERWISE STATED.
- 2 ALL WELDS TO BE D.P. TESTED TO BP 0850199.
- 3 ALL WELDS TO BE GRIII TO AA0622101.
- 4 STRESS RELIEVE ASSY. BEFORE MACHINING TO BP 0640299.
- 5 SURFACE FINISH OF MACHINED SURFACES SHALL BE 3.2 MICRONS OR BETTER.
- 6 PAINTING SHALL BE CARRIED OUT AS PER HG12007.
- 7 APPLY T.R.P. BP0690084 TO ALL MACHINED SURFACES.
- 8 ALL PLATES (40 MM & ABOVE) ARE TO BE ULTRASONICALLY TESTED TO AA0850120 BEFORE CUTTING.
- 9 DIMENSION MARKED THUS '*' ARE FOR DO REFERENCE ONLY.

TOOL LIST		
SI.NO	TOOL NO.	DESCRIPTION

FABRICATED WEIGHT INCLUDING
WELDING = 2275 KG.

001			011	STIFFNER 40TKx230x240 LG. S.S.S.Q PLATE	1		AA1011808196	NA	NO	14.44								
							AA10108											
002			010	STIFFNER 32TKx305x359 LG. S.S.S.Q PLATE	1		AA1011808170	NA	NO	27.40								
							AA10108											
002			009	STIFFNER 32TKx305x534 LG. S.S.S.Q PLATE	1		AA1011808170	NA	NO	40.81								
							AA10108											
001			008	SIDE TOP PLATE 50TKx650x359 LG S.S.S.Q PLATE	1		AA1011808218	NA	NO	91.6								
							AA10108											
004			007	SLING PROTECTOR ø25X275 LG S.S.S.Q ROUND BAR	1		AA1010208128	NA	NO	1.06								
							AA10108											
001			006	PAD 50TKX375X650 LG. S.S.S.Q PLATE	1		AA1011808218	NA	NO	94.46								
							AA10108											
002			005	STIFFNER 32TKx305x1510 LG. S.S.S.Q PLATE	1		AA1011808170	NA	NO	115.59								
							AA10108											
001			004	MAIN RIB 40TKx925x1510 LG. S.S.S.Q PLATE	1		AA1011808196	NA	NO	384.34								
							AA10108											
001			003	TOP PLATE 50TK.x585x650 LG. S.S.S.Q PLATE	1		AA1011808218	NA	NO	149.25								
							AA10108											
001			002	BOTTOM PLATE 50TK.x650x925 LG. S.S.S.Q PLATE	1		AA1011808218	NA	NO	236.00								
							AA10108											
001			001	JOINT PLATE 90TK.x650x1935 LG. S.S.S.Q PLATE	1			NA	NO	888.60								
							AA10108			668.5 (M/C)								
59	64	65	75	78	79	25	27	29	31	34	45	55	56	57	58	65	72	
VAR00			REMARKS	VAR. NO.	ITEM NO.			DESCRIPTION	STD	DRAWING NO.		IT.ND.	MATL. CODE	VAR.	MATL. SPCN.	UNIT	QTY.	ZONE
28 → CARD TYPE-3				28 → CARD TYPE-1				28 → CARD TYPE-2										

ADDITIONAL INFORMATION
W.O. 36201 TO 09 A 23157 STAGE-2
W.O. 36210 TO 18 A 23157 STAGE-3

STATUS OF DRAWING U

DISTRIBUTION OF PRINTS

HGE - 2 TEX - 1
HGM - 2 FWM - 2

REV. DATE ALTERED
CHECKED
APPROVED

mRikn dk i-dkj ;k
xk-gd@fj;kstuk dk uke
TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

HAKsjr gsoh bysfDV&dYl fyfeVsM



HAKsjr
BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

foHAKsjr
DEPT
325000101404

vuqikr
SCALE
1:12.5

HAKsjr fd_xk
WEIGHT (KG.)
2055 M/C

M&kbZax dRk lanHAZ
REF. TO ASSY. DRG.

en d-
ITEM NO.

en laf;k
REV. OF
DRAFT

i="B d-
SHT. NO. 01

i="Bkso dh laf;k
SHT. 01

HMS-713/170-24K
PALAMURU RANGAREDDY LIS STAGE-2&3
(MEIL/TSGENCO)

uke@NAME gLrk_IGN. fnuakdDATE
BKS
NS/BKS
RG/AD

foHAKsjr
DEPT
325000101404

vuqikr
SCALE
1:12.5

HAKsjr fd_xk
WEIGHT (KG.)
2055 M/C

M&kbZax dRk lanHAZ
REF. TO ASSY. DRG.

en d-
ITEM NO.

en laf;k
REV. OF
DRAFT

i="B d-
SHT. NO. 01

i="Bkso dh laf;k
SHT. 01

BOTTOM BRACKET ARM ASSY.
(FAB. & M/C)

2 257 01 89603

en laf;k
REV. OF
DRAFT

i="B d-
SHT. NO. 01

i="Bkso dh laf;k
SHT. 01